

Work Order ID 76777

76777

Page 1

November-21-11 11:09:57 AM

Item ID: D3805-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Assembly Fwd, Low Gear
Start Date: 21/11/2011 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 04/01/2012 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: M.L.J. Date: 11/11/21 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3805	B

100

0.00

1.00

Large Fab

Large Fab

Memo

0.00

1-weld D3806-1 to D3805-1 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M118367

2-Transfer drill holes in bar

2059B → M120028

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

1.10

QC

Quality Control

Memo

0.00

(10) MAL/EL 12/01/20

CPL 12.01.20

10X Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:40								
	OVEN TEMPERATURE: 3200 F								
	FINISH TIME: 1:10								

140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

10X4 M/L 12/01/24

10 & 12/04/20
counted

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Small Fab	Memo	0.00							
Small Fab	1- Bond D3807-1 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: <u>119597</u>								<i>Ac 12.01.25</i>
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							<i>5 12/01/25</i>
Quality Control									<i>(40)</i>
170	Identify as per dwg & Stock Location: <u>FP-1</u>	0.00							
170									
Packaging	Memo	0.00							<i>x10 12/01/26</i>
Packaging									<i>counted & measured</i>

W/O:		WORK ORDER CHANGES					
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 21/11/2011 **Start Qty:** 8.00

8

Cust Item ID:

Required Date: 04/01/2012 **Req'd Qty:** 8.00

8

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

Accept
Qty

Reject
Qty

Reject Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12-01-24
(10)

W/O:		WORK ORDER CHANGES					
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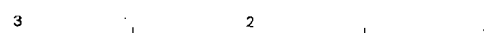
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NOTE: Date & initial all entries

C

RELEASED
2011-10-03
mp

A

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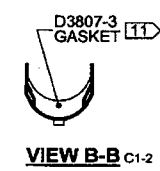
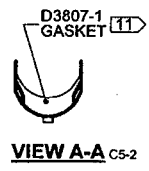
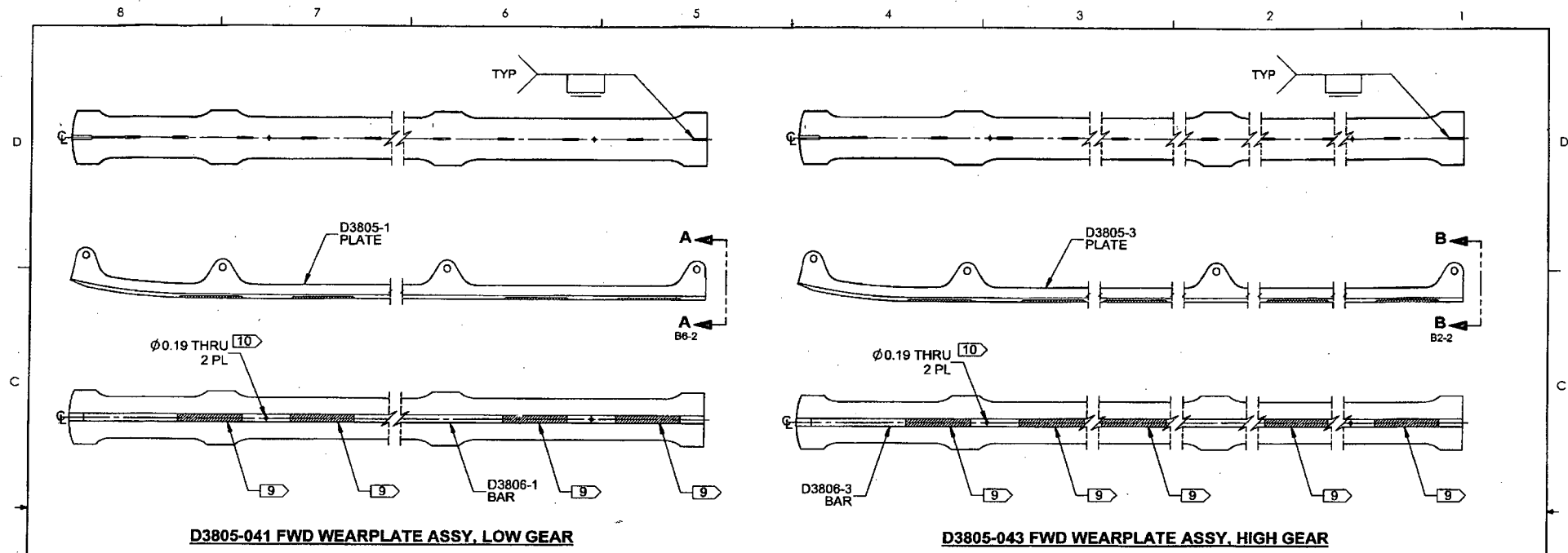
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76777



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2011-10-03

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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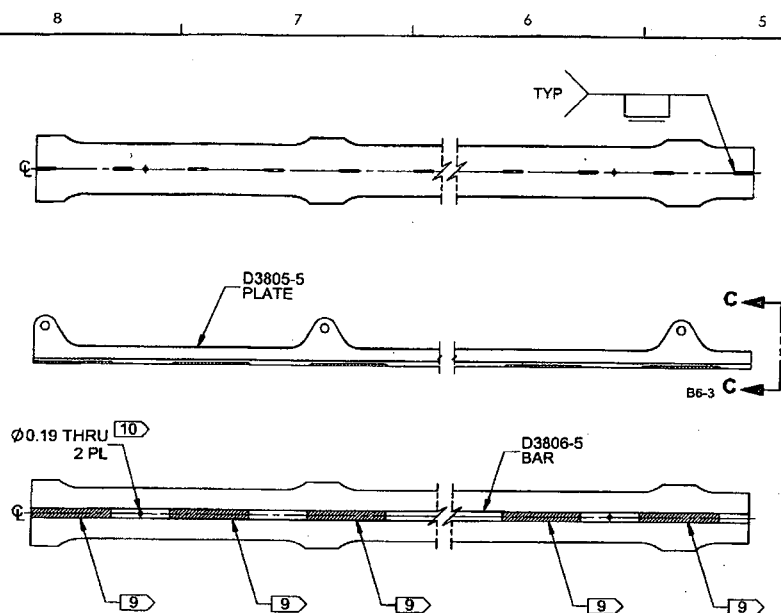
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

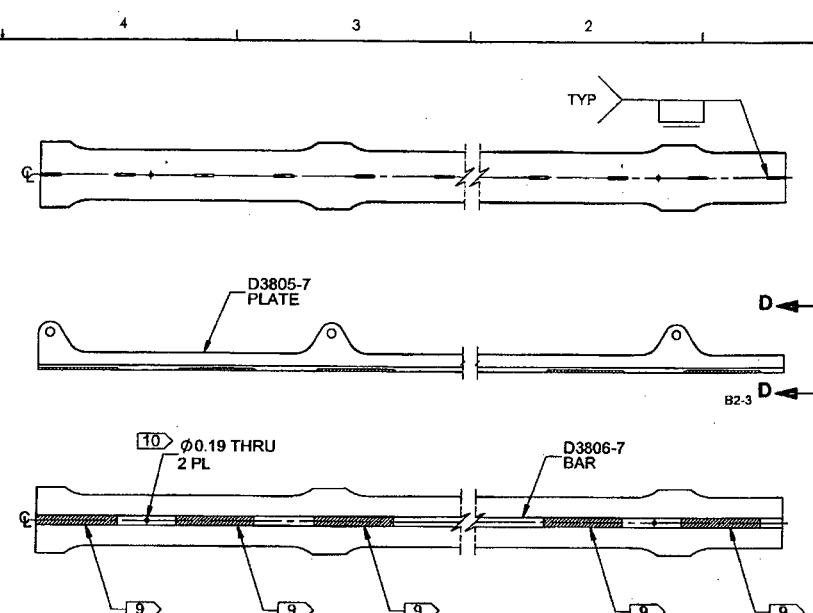
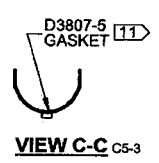
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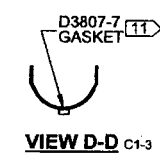
76777



D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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MFG. APPR.		D3805	SHEET 3 OF 8
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2011-10-03
JMP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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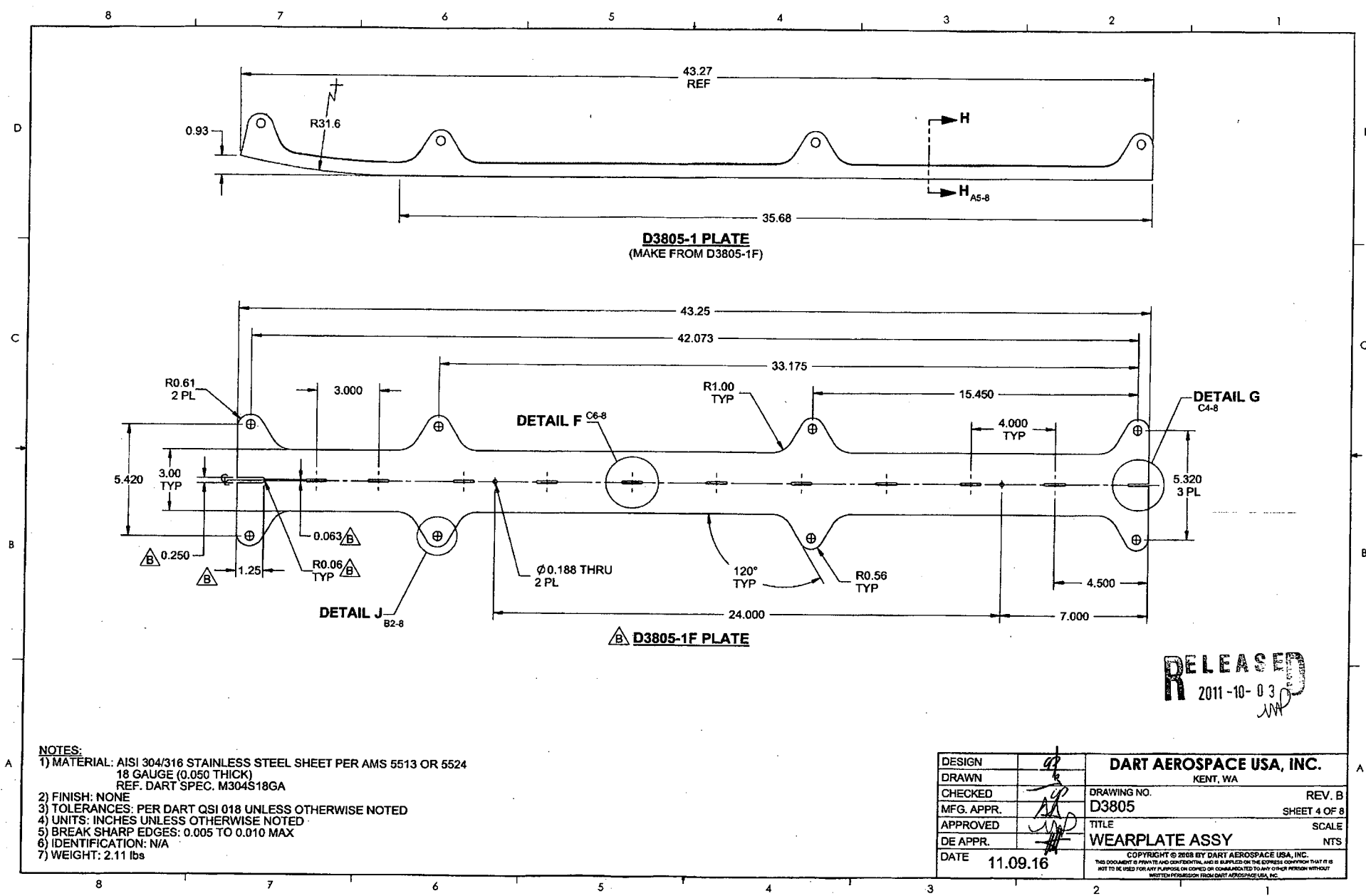
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76777



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

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MFG. APPR.	99	D3805	SHEET 4 OF 8
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D3805-3 PLATE
(MAKE FROM D3805-3F)

D3805-3F PLATE

DETAIL F C6-8

DETAIL G C4-8

DETAIL J B2-8

RELEASED
2011-10-03

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
 18 GAUGE (0.050 THICK)
 REF. DART SPEC. M304S18GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 2.36 lbs

DESIGN	97	DART AEROSPACE USA, INC. KENT, WA
DRAWN	JP	
CHECKED	JL	
MFG. APPR.	[Signature]	
APPROVED	[Signature]	
DE APPR.	[Signature]	TITLE WEARPLATE ASSY
DATE	11.09.16	REV. B SHEET 5 OF 8 SCALE NTS

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RELEASE
2011-10-03

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MFG. APPR.	<i>g</i>	D3805	SHEET 5 OF
APPROVED	<i>g</i>	TITLE	SCALE
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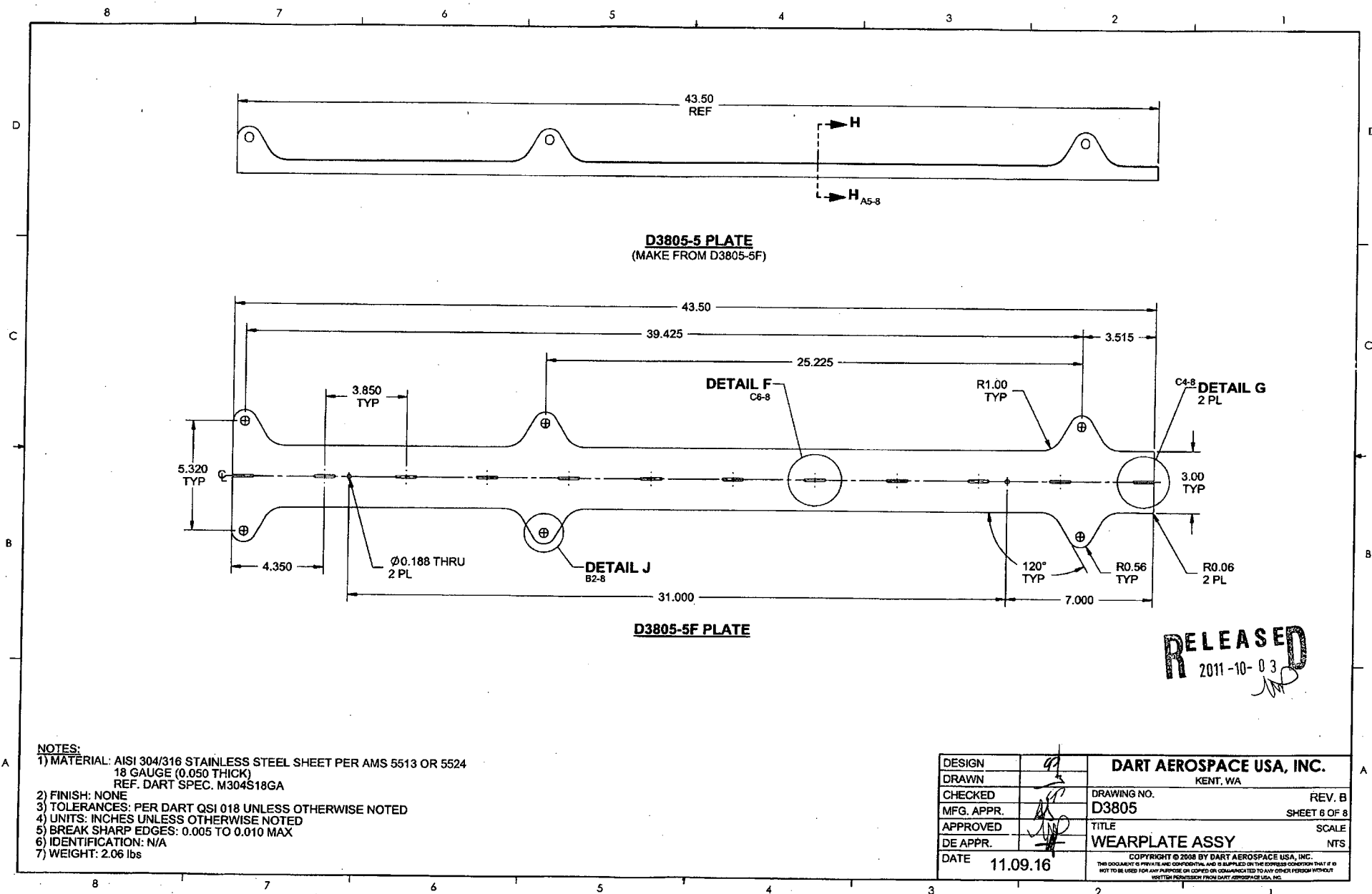
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D3805-5 PLATE
(MAKE FROM D3805-5F)

D3805-5F PLATE

RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

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MFG. APPR.		D3805	SHEET 6 OF 8
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8 7 6 5 4 3 2



A

- 7) WEIGHT: 2.13 lbs

W

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	11.09.16

KENT, WA

REV. B

SCALE

NTS

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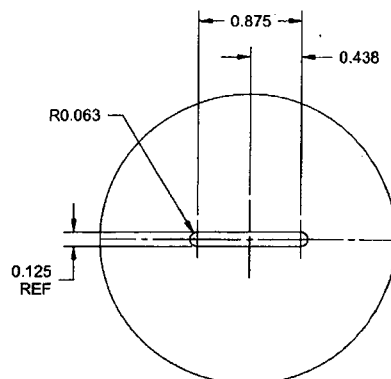
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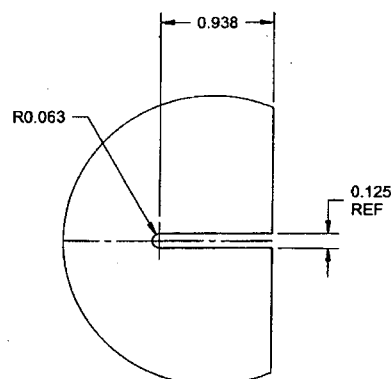
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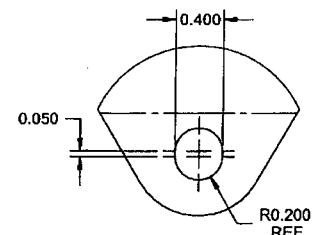
76777



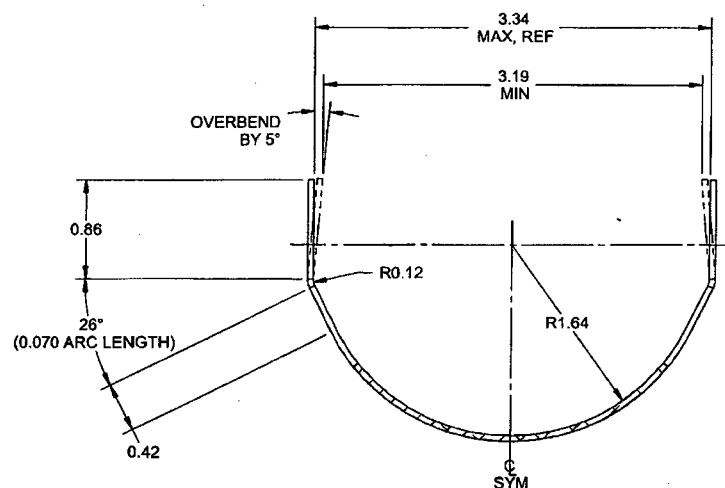
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-03

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		SHEET 8 OF 8	
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